

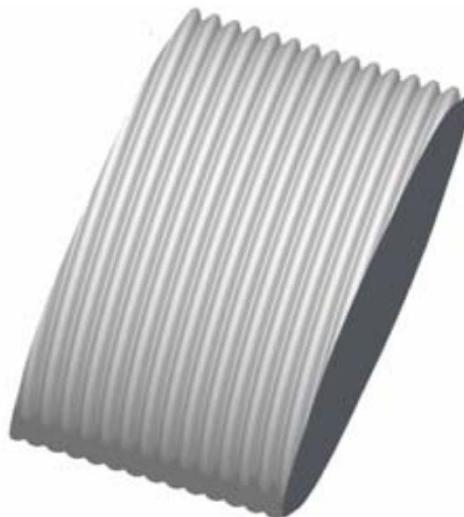
Cylindrical Thread Rolling Die

A21-010

Carbide Cylindrical Thread Rolling Die production with diamond wheels.

Wheel No. 1 dimaond three profiles.

Wheel No. 2 diamond single profile.



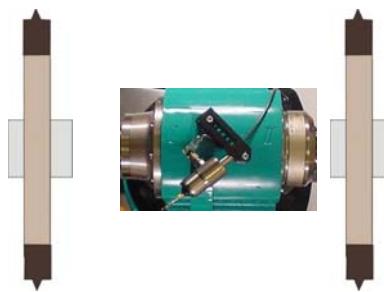
1. Cycletime for Production

Workpiece: Ø178 L76 Z310 P1.805 Helix 21° Material carbide	
Operations	 MainThread  MainThread
Feed [mm/Min]	250 450
Increments [tot./part.]	0.2/0.02 0.01/0.01
Cutting speed [m/s]	22 18
Used wheels	 1  2
Grinding time [s]	3304 5824
Total cycle time	152 Min 8

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø200 D106
2	DXF Ø200 D46



1

2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMACfg

Coolant: Synthetic Oil, pressure 10 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories:

Responsible engineer: OP, 25.5.13

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